






# Work Order ID 63720

Wednesday, November 10, 2010 1:42:19 PM

Page 1

Item ID:	D4035-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Rib Assembly, Fwd (350 Basket)				Stop	
Start Date:	11/10/2010	Start Qty:	1.00			
Required Date:	11/17/2010	Req'd Qty:	1.00			
Reference:						
Approvals:	Process Plan: <u>MF</u>	Date:	10-11-10	Tooling:		
	QC: _____	Date:	_____	SPC (Y/N):	_____	

Cust Item ID:  
Customer:

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY  
MF 10-11-15

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R S.S. rod Batch: 111585 0.00



Large Fab

Large Fab

## Memo

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAD 10-11-11

① Pl 10-11-15

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

## Memo

0.00

10-11-15 1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63720**

Wednesday, November 10, 2010 1:42:19 PM

Page 2

Item ID: D4035-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 11/10/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, November 10, 2010 1:42:19 PM

Page 1

Work Order ID: 63720

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 11/10/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3 Spacer Bushing		Manufactured	No			100	Each	20.0000	1	1			
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Location Loc Qty Loc Code

WA	20	
58974	1	
60320	1	
60952	11	
62108	7	

M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	298.6790	1.75	1.842105			
---	--	-----------	----	--	--	-----	---	----------	------	----------	--	--	--

Location Loc Qty Loc Code

MAT	33.97876794	
113763	0	
114323	20.0582189	
114677	7.69741	
114835	6.223139	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	264.7002	
114992	33.7547	
115260	230.9455	

*Pl 10-11-15*

*①*

*SAD 10-11-11*

*1.8422*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

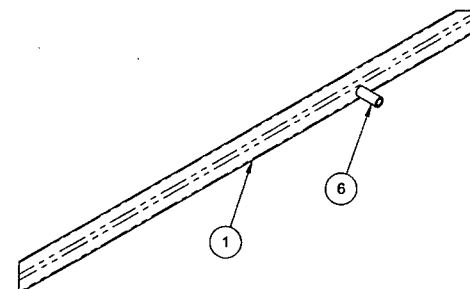
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

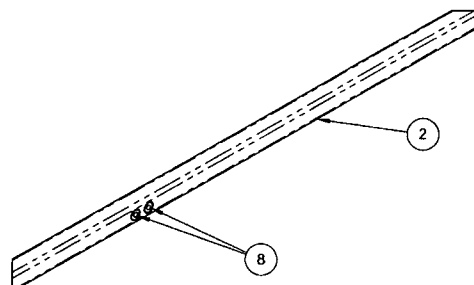
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

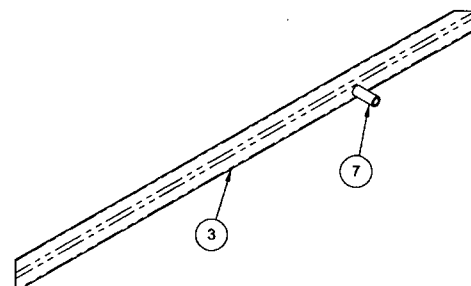
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



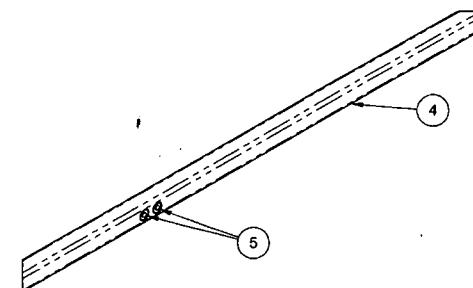
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

A	NEW ISSUE	DESCRIPTION	JPH	10.03.04
REV.			BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4035	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET LID RIB ASSY	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

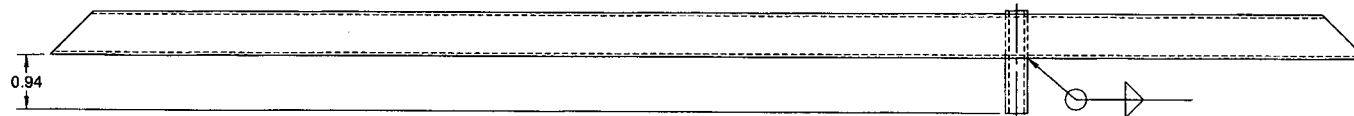
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

G  
G  
TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. <b>D4035</b>	REV. A SHEET 2 OF 5
MFG. APPR.		TITLE <b>BASKET LID RIB ASSY</b>	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	10.03.04		

**RELEASED**  
2010-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL





TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12  
110

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

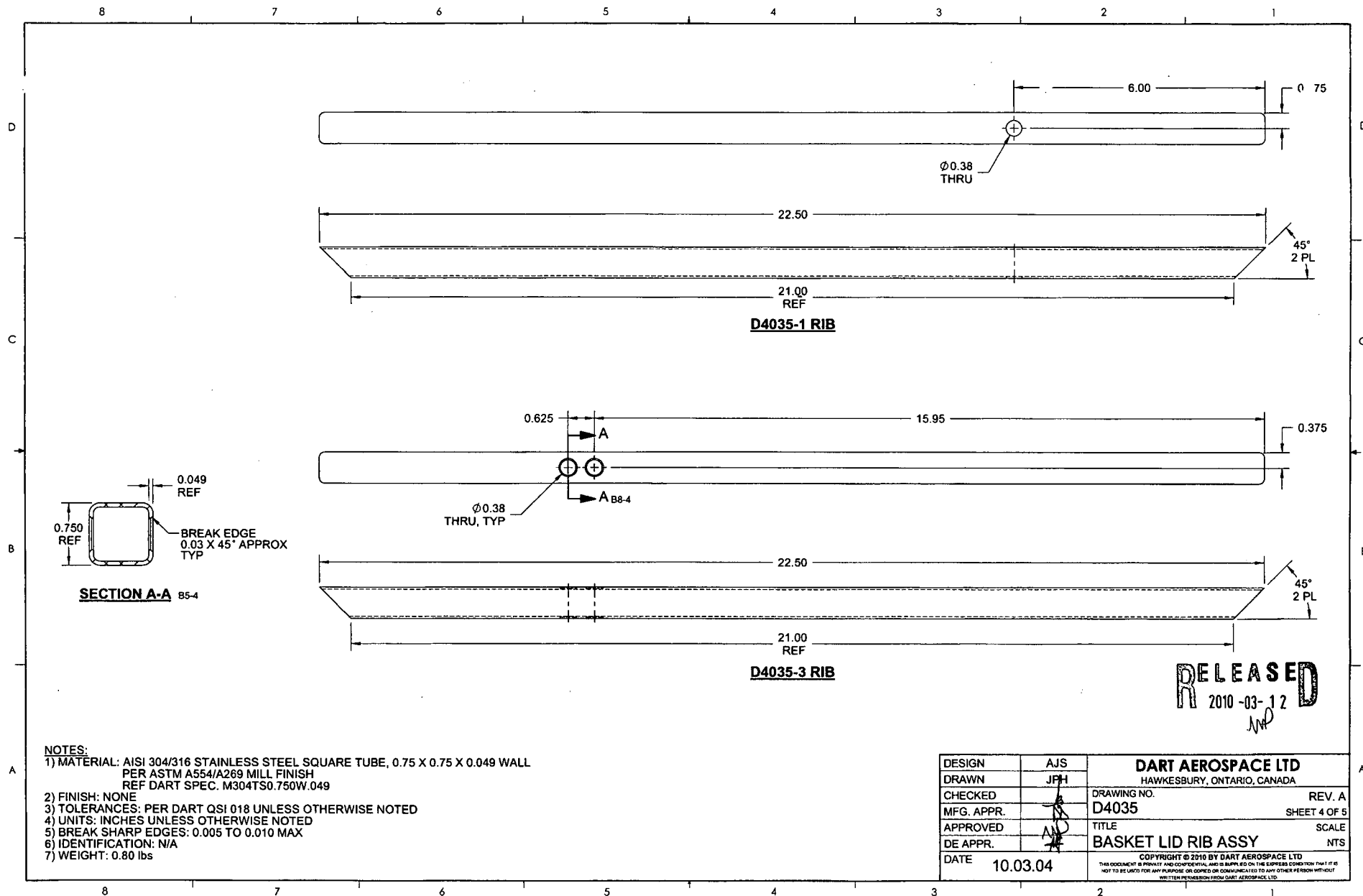
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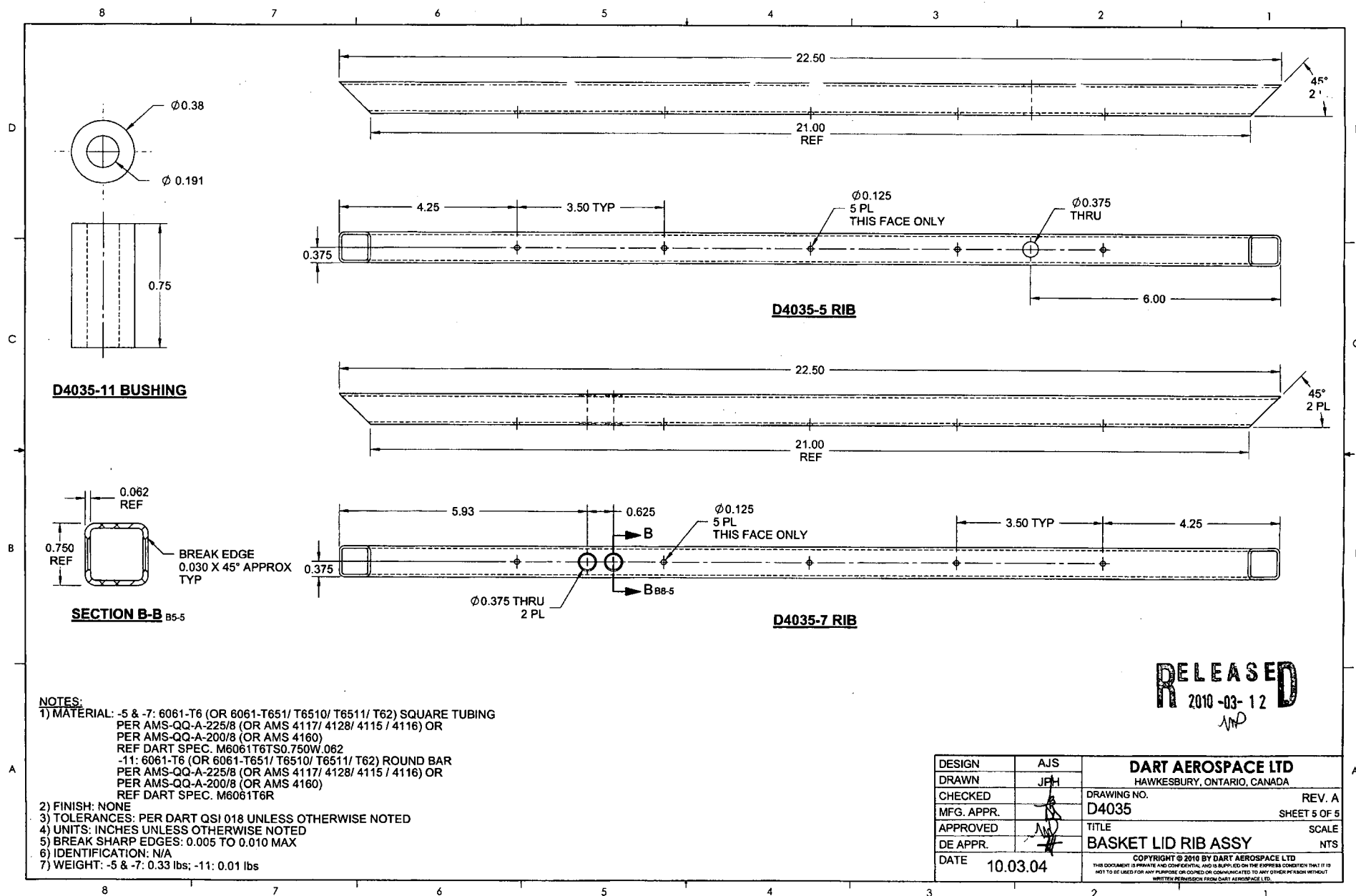
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



## Receiving Report

Date: 10/5/14  
 Supplier: MAGNA

Batch No: 2114677  
 Dart P/O: 11833

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 10105147 N/A ☒

**Discrepancies**

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 10/5/14  
 Date  
 Received/Costing  
 Initial

Location \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

## Purchase Order Receipt Listing

Page 1 of 1

May 14, 2010 2:51:24 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO11833 Receipt Dates from 5/14/2010 to 5/14/2010 All Line Item Types

All Item ID/GL/WOs    All Rec. Employees    All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO11833	1		M304TS0.750W.049 f		5/14/2010	5/14/2010	201.6700	\$4.25	0.0000	0	\$857.10
CAD	No		304 SQ Tube f		200.0000	DCUSER		\$857.10	0.0000	0	
			.75x.75x.049W								
			114677								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Magna Stainless**

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

**PACKING LIST**

Page 1 of 1

I027101

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY, ON  
K6A 1K7  
Contact: CHANTAL

HAWKESBURY, ON  
K6A 1K7  
Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO11833		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W029306	NET 30 DAYS		NIR:R-557065-1		05/05/10	05/18/10	05/14/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
10		PC	STAINLESS - FT 304 MF 3/4" SQ X .049 X 20'2 201.67 FT / 10 PC	L039225	4AL7	10 10
Bundles: 1				Approx Weight:		10 LB

*Prop 14*

Received by: \_\_\_\_\_ Date: \_\_\_\_\_ Signature: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11833

Purchase Order Date 5/05/10

PO Print Date 5/05/10

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
6/10/14

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	5/14/10	200.00	Yours ppd	\$4.2500	\$850.00

Yes

Special Inst:

MATERIAL: AISI 304/316 SEAMLESS  
STAINLESS STEEL SQUARE TUBING AS  
PER ASTM A554 MILL FINISH OR  
ASTM A269 MILL FINISH

PO Total:

\$850.00

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 5/05/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# PHOENIX TUBE COMPANY, INC.

Manufacturer of Stainless Ornamental and Structural Tubing

## CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.  
5775 RUE KIERAN

Ship To: MAGNA STAINLESS INC.  
5775 RUE KIERAN

SAINT-LAURENT QC H4S  
CAN

SAINT-LAURENT QC H4S  
CAN

CUSTOMER ORDER#: P0010057

Phone# 3391211

Ext:

CUST REF NBR:

ORDER#: 218833

DATE SHIPPED: 06/10/10

QTY SHIPPED: 202.0

SIZE: 3/4SQ X 18 GA AW

GRADE: 304

WELD: HF

SOURCE: USA D

HEAT#: 4AL7

VENDOR: NAS

TEST REPORT#: TR007814

Report Date: 08/09/08

Specification:

ASTM A554-08a

NO WELD REPAIR

8.10.05/117

POST

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

### Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2	T1
.04	1.71	.03	.0103	.31	18.27	8.07	.30	.36	0	.04	0

### Physical Analysis

	YIELD		TENSILE		OTHER	
Hardness	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 80	49860	0	98050	0	48.9	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.

PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

*Sanctus*

1185 WIN DR BETHLEHEM, PA, 18017 - (610) 865-5337

FAX NUMBER: 610-865-4073

C5323

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries